



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3201-4
Job Sheet 170347



Part No: D3201-4

Job Qty: 10 ea

Part Name: Angle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 1/23/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM IPP
Rev :C Added scribing, NCR262 07.11.29 EC IPP Rev:D 10.10.29 remove scribe b# & p# DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/22/18	1/22/18	0.00	0.00	Start Up Waterjet		SC 18/01/16
100	Waterjet	10 pcs	1/22/18	1/22/18	0.00	0.23	Waterjet1		SC 18/01/16
120	QC	10 pcs	1/22/18	1/22/18	0.00	0.00	QC8		38
140	Brake NC	10 pcs	1/22/18	1/22/18	0.09	0.22	Brake NC 1		38
150	QC	10 pcs	1/22/18	1/22/18	0.00	0.00	QC5		38
160	HandFinish	10 pcs	1/23/18	1/23/18	0.00	0.28	HandFinish1		2018-01-18
170	QC	10 pcs	1/23/18	1/23/18	0.00	0.00	QC7-2		38
180	Packaging	10 pcs	1/23/18	1/23/18	0.00	0.00	Packaging3-1	57023	AT 9-88 18/01/19
190	QC21-SA	10 Ea	1/23/18	1/23/18	0.00	0.00	QC21		DAS

Part Op 100 - 1-Cut as per Dwg D3201 (CHECK GRAIN DIRECTION BEFORE CUTTING)
Descriptions: 140 - 1-Bend as per Dwg D3201

21 9-88 JAN 22 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.050	0	48	0	0

4137762

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.760inches ± 0.030	3.790 3.730		
2	Doubler	3.460inches ± 0.030	3.490 3.430		
3	Doubler	1.680inches ± 0.030	1.710 1.650		
4	Doubler	0.050inches ± 0.010	0.060 0.040		

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	
		Completed By	

Job No: 170347 Start up Operation 01/17/18	Change No: _____	Lead hand / Supervisor Approval Verification
	Operation: _____	
	Revision: _____	
	Original Serial #: S032996	QC / QA Coordinator Approval
PART NO: D3201-4		

Root Cause			
Environment ☐	No Re-verification ☐	Pre: ☐	Positioned Wrong
Design ☐	Operator ☐	Ben ☐	Outside Dimensions
Doc/Data ☐	Offset/Setup ☐	Cen ☐	Over/Under tolerance
Equip/Tooling ☐	Supplier ☐	Crac ☐	Part Incorrect
Handling/Pre ☐	Training ☐	Crin ☐	Part Lost/Missing
Material ☐	Use for Testing ☐	Cufl ☐	Part Moved
Internal Transport ☐	Poor Information ☐	Cru: ☐	Drawing
Tribal Knowledge ☐	Rushing ☐	Hea ☐	Finish
LOA ☐	Product Improvement ☐	Wav ☐	Misread
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

S032996
DART AEROSPACE

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Drill Holes ☐ Misaligned/off center ☐



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3201-4 Revision: Angle														
190	QC21-SA	S032996	170347	10 Ea	0	S032996	ST023	Bin	Stock	1/17/2018	Issue Container			
Operation Totals:		1		10	0									
Part Totals:		1		10	0									
Part Number: M2024T3S.050 Revision: 2024-T3 .050 Sheet														
100	Receive sf	S032995	170347	0 sf	0	M137762	Start Up Waterjet		Stock	1/17/2018	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		10	0									

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								